

FIG. 1

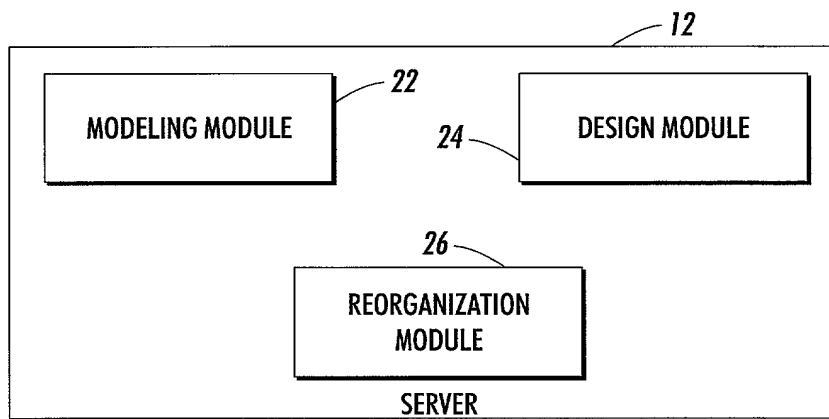


FIG. 2

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MODELS:
BUSINESS CARDS
EMPIRE
PRUDENTIAL

SIMULATIONS FOR LDF
START LIST JOB MODELS QUIT HELP TO LDF HOMEPAGE

MODEL: EMPIRE

32 → B&W PRINTING → 34 → PUNCHING → 36 → COIL BINDING → 38 → VERIFICATION → RUN MODEL

SPECIFICATION PARAMETERS:

BOOKS	100
PAGES/BOOK	100
NUMBER OF BATCHES	1
NUMBER OF AVAILABLE OPERATORS	2
PRINT SETUP TIME (HR)	0.02
PRINT SPEED (PAGES/HR)	6000
"NUMBER" OF OPERATOR(S) REQUIRED FOR PRINTING (%)	50
PUNCH SETUP TIME (HR)	0.02
PUNCH SPEED (PAGES/HR)	20000
"NUMBER" OF OPERATOR(S) REQUIRED FOR PUNCHING (%)	50
COIL SETUP TIME (HR)	0.05

MODEL: EMPIRE

ANALYTICAL TREATMENT:
 (FOR UNLIMITING OPERATOR RESOURCE)
 THE OPTIMAL NUMBER OF BATCHES IS
 AROUND 8.8 WITH COMPLETION TIME
 CLOSE TO 2.09 HRS
 AS LIMITED BY THE BOTTLENECK(S):
 BW PRINTING
 COMPUTE PLOT

ACTUAL SIMULATION:
 COMPLETION TIME = 3.31 HRS.

FIG. 3

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☐ Deterministic

☒ Exponential

Mean Time To Failure (Machine 1)	Mean Time To Failure (Machine 2)	
9600	9600	9600
Mean Time To Repair (Machine 1)	Mean Time To Repair (Machine 2)	
20	20	20
Mean Production Time (Machine 1)	Mean Production Time (Machine 2)	
1.0	1.0	1.0
Buffer Size (<10000)		
100		

Steady State Production Efficiency

Average Buffer Level

0.0

Compute System Performance

52 {

54 {

FIG. 4